

Date: Tuesday, 10/2/2007 10:43:59 AM
 User: Kim Johnston

Process Sheet

41

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLEVIS
Job Number : 34942	
Estimate Number : 10574	
P.O. Number : <u>N/A</u>	Part Number : D34531
This Issue : 10/2/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3453 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>MA</u> Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 29677	Material : <u>N/A</u>
Written By : <u>JA</u>	Due Date : 10/9/2007
Checked & Approved By : <u>JA 07.10.02</u>	Qty: <u>2</u> Um: Each
Comment : A 05.09.27 New issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M304R1.250 <u>R1.500</u> <u>JA 07-10</u>	Inventory
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Comment: Qty.: 0.2880 f(s)/Unit Total : 2.8800 f(s)
 Material: AISI 304 SS Round Bar Ø1.250
 (M304R1.250)
 Batch: M101549

RP 07/10/03 278

2

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL
 1-Turn as per Folio FA577 Rev: A & Dwg D3453 Rev: A
 2- Deburr as per dwg D3453

RP 07/10/03

2

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

RP 07/10/03

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 1-Mill as per Folio FA577 Rev: A & Dwg D3453 Rev: A
 2- Deburr as per dwg 3453

JA 07-10-05 2

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JA 07-10-05 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: LD Date: 07/10/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/2/2007 10:43:59 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 34942

Part Number: D34531

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1- Drill as per dwg D3453

2-Deburr as per dwg D3453

Jul 07.10.04 (2)

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

EC 07.10.04 (2)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

W

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12/11/04

Job Completion



u 07.10.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	34942
Description: Clevis		Part Number:	D3453-1
Inspection Dwg: D3453 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.438	+0.006/-0.001	Ø.4385	✓			
R0.25	+/-0.030	R.250	✓			
0.450	+/-0.010	.448	✓			
0.625	+/-0.010	.627	✓			
0.063 x 45°	+/-0.010 x 0.5°	.063 x 45	✓			
Ø0.129	+0.005/-0.001	Ø.131				
3.26	+/-0.030	3.243	✓			
1.00	+/-0.030	.990	✓			
1.550	+/-0.010	1.553	✓			
Ø0.500	+0.010/-0.000	Ø.499	✓			
0.263 x 45°	+/-0.010 x 0.5°	.263 x 45°	✓			
Ø1.13	+0.012/-0.001	1.129	✓			
Ø0.500	+0.000/-0.005	.499	✓			

Measured by:	<i>[Signature]</i>
Date:	07-10-04

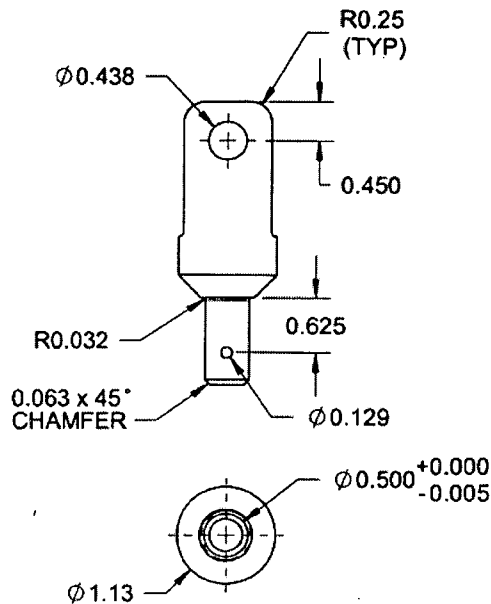
Audited by:	<i>[Signature]</i>
Date:	07.10.04

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.06.30	New Issue	KJ/JLM	
B	07.01.17	Dimensions added	KJ/JLM	



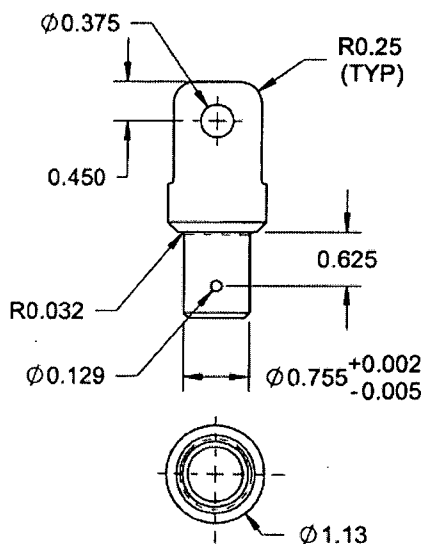
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3453	REV. A SHEET 1 OF 2
DATE 05.09.02	TITLE CLEVIS		SCALE 1:2
A	05.09.02	NEW ISSUE	



D3453-1 CLEVIS

RELEASED

05.12.09



D3453-3 CLEVIS

NOTES:

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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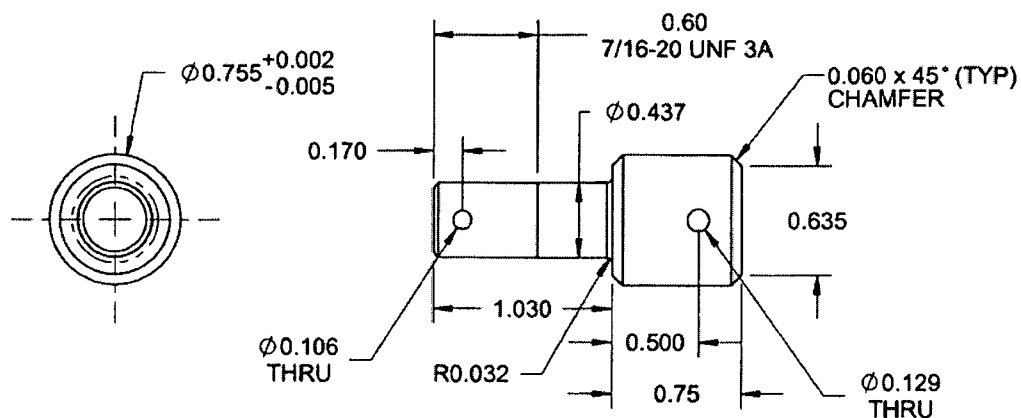
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3453	REV. A SHEET 2 OF 2
DATE 05.09.02		TITLE CLEVIS	SCALE 1:1

RELEASED

05.12.09 [Signature]



D3453-5 PLUG

NOTES:

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC. M304R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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